Work Ord October-04-13	10.51.12 434			*105				Page 1				
Item ID: Revision ID: Item Name:	646.3717 Doubler	646.37 B10598	1 7 3 2	Accept	*N900	040	100)* s	etup Sta	1.71	S1* S2*	
Start Date: Required Date	10/04/13	Start Qty: 23.00 Req'd Qty: 23.00	*23*		Cust Item I Customer:	D:						
Approvals:	Process Plan	n: MC5	Date: <u>\</u>	Tooling: SPC (Y/N):		ate:		R	tun Sta	I/I	R1* R2*	
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	_
Draw Nbr	Revi	sion Nbr										
646.3700	A											
110				0.00								
110 Waterjet FLOW CNC Water	jet	Memo 1-Cut as p	er Dwg	0.00				24	_0		JM13-10	ع- 00
		Dwg Rev: Prog Rev:									· .	
		2-Deburr	f necessary									
120		QC2- Inspect parts off	machine FAI/FAIB	0.00								
120				0.00				24			JMB-	10-0
QC		Memo		.0.00								

Memo

Quality Control

NCR:	Yes	1	No
NCK.	res	/	NO

													* *	
								•			DQA:	Date:	. <u>p</u>	
NCR: Ye	es / No				WORK ORDER NON	-COi	NFORM	MANCE / UPI	DATE	Q,	A Closed:	Date	* ' F	
Work Order	·-				DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Part No	Rework Skid-tube Crosstul Scrap Machining Small Formula Shid-tube Thermoforming Finishing Small Formula Shid-tube Crosstul						Crosstube Small Fab Finishing Composite		Engineering Quality Other					
Root					ption of work order update		Initial	ì	tion		Sign &	-		
Cause	Date	Step	Qty		or Non-conformance	Cr	nief Eng	Desci	ription		Date	Verification	QC Inspector	
Doc/Data	_													
quip/Tooling	_													
Operator	_					-								
Material						Ì						ļ		
Setup	\dashv													
Other Process						1								
Supplier	\dashv	1								`				
Training	=					į								
Unapproved	7													
	- 1	<u> </u>	<u> </u>			FAUI	LT CATE	GORY		•		·		
Landin	g Gear				General									
Γ	Bending				Bend		Grain			По	valized		Pressure/Forced	
	Centre N	ot Conce	ntric to	o/s	BOM/Route		Hardwa	are		o	ver/Under	tolerance	Temperature/Cure	
[Cracks				Broken/Damaged		Inspect	ion Incomplete		Pa	art Incorre	ct	Weld	
	Crushed	/Crimped			Burrs		Instruct	tions Incomplete/	Unclear	Pa	art Lost/M	issing	Wrong Stock Pulled	
	Cuffs				Contamination		Mainte	enance		∐]Pä	art Moved			
	Heat Tre	at			Countersink		Mislabe	eled		∐ P¢	ositioned V	Wrong	<u> </u>	
	Inspection	n Strip ir	Tube		Cut Too Short		Misrea	d		L Po	ower Loss/	'Surge	Other	
	Ripples i	n Bend			Drill Holes		Offset			_		# * ***		
[Torque \	Vaves in	Extrusio	n [Drawing		Out of	Calibration						
	Turning	Sequence	:		Finish	L	Out of	Sequence						
	Wave/Tv	vist in Tu	be	ļ	Folio		Outside	e Dimensions						

Work Order ID October-04-13 10:51:12			*	1059	182*							Page 2	!
Item ID: 646.371' Revision ID: Item Name: Doubler	7		Accept		*N900	040	100	ገ*	Setup	Start Stop	IV	S1* S2*	
Start Date: 10/04/13 Required Date: 10/18/13 Reference:		*23* *23*			Cust Item I Customer:	D:							
• •	Plan:	Date:	Tooling SPC (Y			ate:			Run	Start Stop	*N *N	R1* R2*	
Sequence ID/ Work Center ID 130 *130* QC Quality Control	Operation Description QC8- Inspect parts - seco	and check	Set 1 Run 0.00	Up/ Неукія 27 9-89 В-Ю-	Tool ID	Tool #	Plan Code	Accept Qty 24	Rej Qty		Reject Number	Insp. Stamp	
140 *110* Outsource4 Outsource process - Anodize	1- Black And 2- PRIME A	ze per QSI017 4.1.10.1 ATG:	0.00					(1)	<u>L</u> 1	3/10	0/09	2/	

150

Receive & Inspect for Damage & Mat'l Certs

0.00

150 Packaging

ing Memo

0.00

Packaging

(1-13/1-/31 (24)

											DQA:	Dat	e:	F F
NCR:	Yes	/ No	·			WORK ORDER NON-	-CO	NFORM	MANCE / UPI	DATE	OA Classid	D-4		*
								ı			QA Closed:	Dat	æ:	
Work Orde	or.					DISPOSITION								
WORK OTUC	٠٠٠.					Rework	٦	1	Skid-tube	Crosstube	1	Water Jet		Engineering
Part N	No.					Scrap	1	Machining Small Fab			Prod. Eng. Coor.			Quality
							1	1	noforming	Finishing	Rec/Store/Packaging			Other
NCR I	۷o.					Work Order Update			Large Fab	Composite]	Supplier		
Root					Descri	ption of work order update		Initial	Act	tion	Sign &			
Cause		Date	Step	Qty	•	or Non-conformance	CI	nief Eng	Desci	ription	Date	Verification	1	QC Inspector
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Operator			ŀ			•								
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Supplier	$oxed{oxed}$													
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Unapproved	<u> </u>										<u> </u>			<u> </u>
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Landi	_	1			_	General		٦		_	¬	i		!
	<u> </u>	Bending			_	Bend	\vdash	Grain			Ovalized			Pressure/Forced
		Centre N	ot Conce	ntric to	o/s	BOM/Route	\perp	Hardwa		·	Over/Under			Temperature/Cure
	<u></u>	Cracks			<u> </u>	Broken/Damaged		⊣ `	on Incomplete	_	Part Incorre			Weld
	<u></u>	Crushed/	Crimped		<u> </u>	Burrs	<u> </u>	┥	ions incomplete/	Unclear	Part Lost/M	- ,		Wrong Stock Pulled
Cuffs Contamination Maintenan						<u> </u>	Part Moved							
		Heat Trea	-		<u> </u>	Countersink	L	Mislabe			Positioned Wrong			1
		Inspectio	n Strip in	Tube		Cut Too Short		Misread	1		Power Loss,	/Surge		Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

XX / I	Order	1115 14	15007
	IPMAR		INUX
** ** **		11/ 11	J., 7 () 4

105982

Page 3

October-04-13 10:51:12 AM Item ID: 646.3717 Accept *N900040100* Setup Start Revision ID: Stop Doubler Item Name: **Start Qty: 23.00** Start Date: 10/04/13 **Cust Item ID:** Req'd Qty: 23.00 Required Date: 10/18/13 **Customer:** Reference: Run Approvals: Process Plan: _____ Date: ____ Tooling: Date: Stop QC: _____ Date: ____ SPC (Y/N): Date: Sequence ID/ Operation Tool ID Tool # Plan Set Up/ Reject Reject Accept Insp. Work Center ID Description Code Number Stamp **Run Hours** Qty Qty 160 QC5- Inspect part completeness to step on W/O 0.00 DAS *160* 27 0.00 **9.89** [S.11,0] Memo Quality Control Identify as per dwg & Stock Location: 57523A 0.00 190 24x 28 /3-11-1 *100* Packaging 0.00 Memo ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING THE P# AND Packaging REV*** A)/21/3-11-5 P2/3-11-01 QC21- Final Inspection - Work Order Release 0.00 0.00 Memo Quality Control

												DQA:	Da	ate: _	, ,
NCR:	es/	/ No				WORK ORDER NON-	100	NFOR!	/ANCE / UPI	DATE	QA	Closed:	Da	ate:	•
Morte Orde						DISPOSITION				AGAINST DE					
Work Orde	-					Downst -	1		Skid tuba	Crosstube	٦		Water Jet	\Box	Engineering
Don't 8	ما					Rework	-		Skid-tube Machining	Small Fab	┨	Dro	d. Eng. Coor.	\vdash	Quality
Part N	NO	· · · · · · · · · ·				Scrap Use-as-is			noforming	Finishing	┨.		e/Packaging	-	Other
NCR I	No.					Work Order Update	1	mem	Large Fab	Composite	┤ '	(60/300)	Supplier	_	
NCK	' ''					Work Order opdate		l	carge rab	composite			Supplie	ш	لــا
Root					Descri	ption of work order update	П	Initial	Act	ion	Si	ign &			
Cause		Date	Step	Qty		or Non-conformance	Ch	nief Eng	Descr	ription	1	Date	Verification	n nc	QC Inspector
Doc/Data												Î			
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Operator															
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Setup							1							1	
Other															
Process			[ļ											
Supplier							ļ								
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Landi	ng G	ear			_	General	_	_			_				
		Bending			L	Bend		Grain		L	Ova	lized		Ш	Pressure/Forced
	Ш	Centre No	ot Conce	ntric to	o/s	BOM/Route	L	Hardwa	ire		Ove	er/Under	tolerance	\square	Temperature/Cure
	Ш	Cracks				Broken/Damaged		Inspecti	ion Incomplete		Part	t Incorrec	t		Weld
	Ш	Crushed/	Crimped			Burrs		Instruct	tions Incomplete/l	Unclear	Part	t Lost/Mi	ssing		Wrong Stock Pulled
		Cuffs			-	Contamination		Mainte	nance	ŀ	Pari	t Moved			

Mislabeled

Out of Calibration

Out of Sequence

Outside Dimensions

Misread

Offset

Positioned Wrong

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

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' Picklist Print

`October-04-13 10:51:20 AM

Work Order ID: 105982

Parent Item Name: Doubler

Parent Item:

646.3717

105982

646 3717

Start Date: 10/04/13

Required Date: 10/18/13

Page 1

Start Qty: 23.00

Required Qty: 23.00

Comments:

IPP REV:A 12.10.22 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063		Purchased	No			110	sf	636.2905	0.036		-		
M6061T6	SS 063								**			J^	20.06

6061-T6 .063 Sheet

Location	Loc Qty	Loc Code	
MAT021	636.2905		
123135	120.2625		
124003	72.113		
M126075	107.915		126075
M127006	336		

						•			DQA:	Date:	
NCR: Y	es / No				WORK ORDER NON-C	ONFOR	MANCE / UPD		QA Closed:	 Date:	,
Work Orde					DISPOSITION			AGAINST DE			
Part N					Scrap Machining Small Fab Use-as-is Thermoforming Finishing			Crosstube Small Fab Finishing	1	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR N	lo			'	Work Order Update Large Fab Composite			Composite		Supplier	
Root		T		Descri	ption of work order update	Initial	Acti	ion	Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Chief En	g Descr	iption	Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup						İ					
Other		1									
Process											
Supplier											
Training											
Unapproved											
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Landi	ng Gear				General				7	,	7
	Bending				Bend	Grain		<u> </u>	Ovalized		Pressure/Forced
	Centre No	ot Conce	ntric to	o/s	BOM/Route	Hardv	/are		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	Inspec	ction Incomplete		Part Incorre	ct	Weld
	Crushed/	Crimped			Burrs	Instru	ctions Incomplete/U	Jnclear	Part Lost/Mi	issing	Wrong Stock Pulled
	Cuffs				Contamination	Main	tenance		Part Moved		
	Heat Trea	at			Countersink	Mislal	peled		Positioned V	Vrong	

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

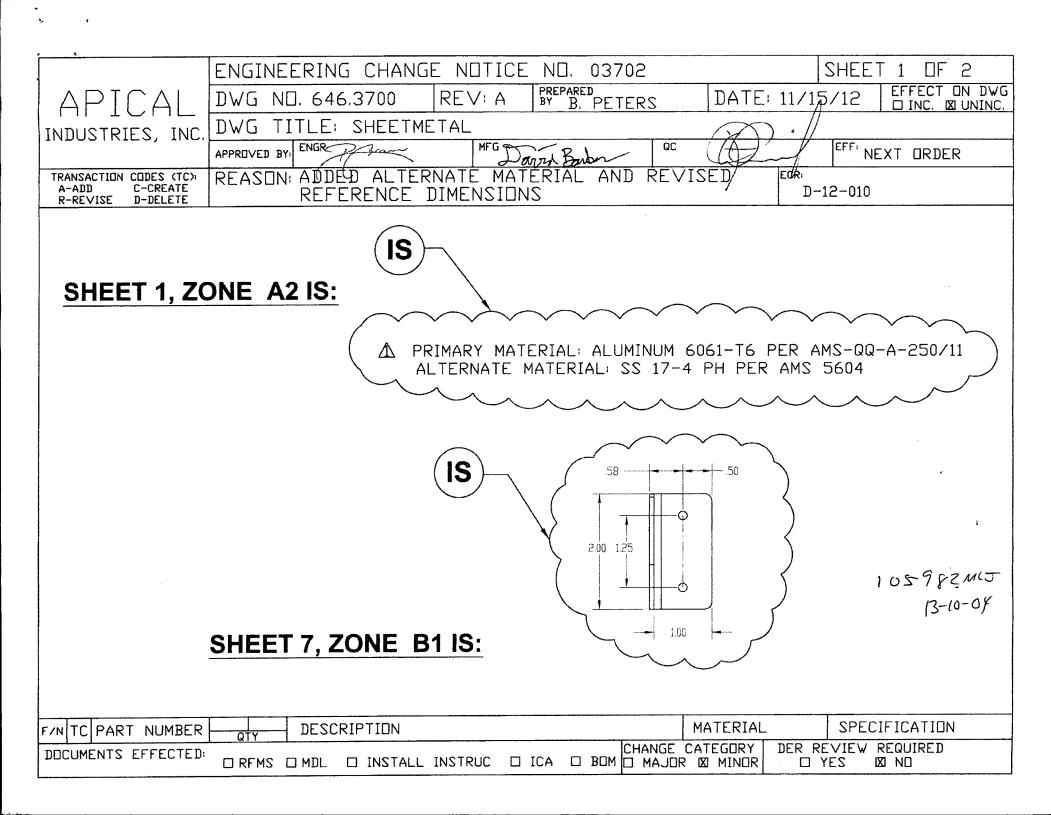
Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish



NCR:	Yes	/	No
		,	

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _______

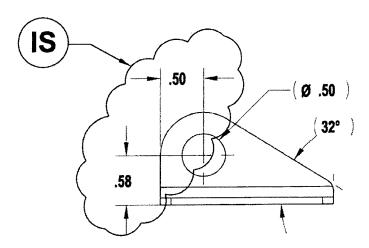
NCK: YE	es / NO				WORK ORDER NON-C	JOINFO	MIVIF	ANCE / OF	DATE	QA Closed:	Date	:
Work Ordei	r :				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part N					Rework Scrap	ap Machining Small Fab Prod. Eng. Coor.						
NCR N	0				Use-as-is Work Order Update] Th		orming rge Fab	Finishing Composite	Rec/Stoi	re/Packaging Supplier	Other
Root			<u> </u>		ption of work order update	Initia			tion	Sign &		061,
Cause	Date	Step	Qty		or Non-conformance	Chief E	ng	Descr	ription	Date	Verification	QC Inspector
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Other		1				1						
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Inapproved								<u>. ·</u>				<u> </u>
						AULT CA	ATEGO	RY				
Landin	g Gear				General				م	7	-	٦ -
<u> </u>	Bending				Bend	Gra			<u> </u>	Ovalized	<u> </u>	Pressure/Forced
	Centre No	ot Conce	ntric to (o/s	_BOM/Route	Hard	dware		L	Over/Under	tolerance	Temperature/Cure
L	Cracks				Broken/Damaged	Insp	ection	Incomplete		Part Incorre	ct	Weld
	Crushed/	Crimped			Burrs	Inst	ruction	ns Incomplete/l	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
,	Cuffs				Contamination	Mai	intena	ince		Part Moved		
	Heat Trea	at			Countersink	Misl	labeled	t		Positioned V	Vrong	
	Inspectio	n Strip in	Tube		Cut Too Short	Mis	read			Power Loss/	Surge	Other
	Ripples in	n Bend			Drill Holes	Offs	set		_			
Ī	Torque V	Vaves in E	extrusion	n	Drawing	Out	of Cali	bration				
Ţ	Turning S	Sequence			Finish	Out	of Seq	uence				
ľ	Waye/Tw	uist in Tul	20		Folio	Пои	side Di	mensions				

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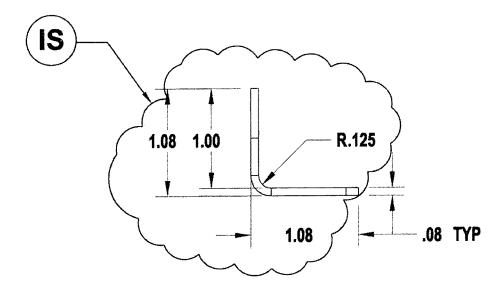
APICAL INDUSTRIES, INC.

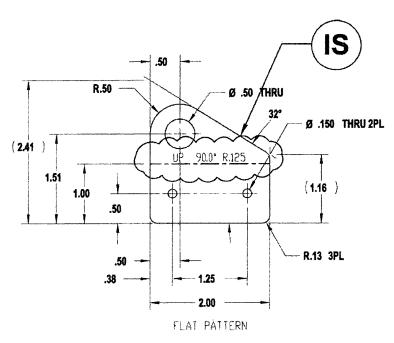
ENGINEERING CHANGE ORDER NO. 03702

SHEET 2 OF 2



SHEET 7, ZONE C4 IS:





SHEET 7, ZONE B7 IS:

SHEET 7, ZONE D1 IS:

F/N TC PART NUMBER

QTY

DESCRIPTION

MATERIAL/SPECIFICATION

									DQA:	Date:	
NCR: Y	es / No		-		WORK ORDER NON-	CONFORM	MANCE / UP	DATE	QA Closed:	 Date:	,
Mork Orda				····	DISPOSITION			AGAINST DE			
Work Orde					Rework	4 8	Skid-tube Machining	Crosstube Small Fab	Pro	Water Jet d. Eng. Coor.	Engineering Quality
Part N					Scrap	4 I	~ ⊢—	ļ	4		Other
NCR N	lo				Use-as-is Work Order Update	Inem	noforming Large Fab	Finishing Composite	Rec/Sto	re/Packaging Supplier	Other
Root			•	Descri	ption of work order update	Initial	Ac	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Desc	ription	Date	Verification	QC Inspector
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Equip/Tooling											
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Other			1			-					
Process						1					
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Unapproved											
					F	AULT CATE	GORY				
Landi	ng Gear				General				_		-
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	Centre	Not Conce	ntric to	o/s	BOM/Route	Hardwa	ire		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	Inspect	ion Incomplete		Part Incorre	ct	Weld
	Crushed	I/Crimped			Burrs	Instruct	tions Incomplete/	Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs				Contamination	Mainte	enance		Part Moved		
	Heat Tr	eat			Countersink	Mislabe	eled		Positioned V	Wrong	_
	Inspect	on Strip in	Tube		Cut Too Short	Misrea	d ·		Power Loss/	Surge	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

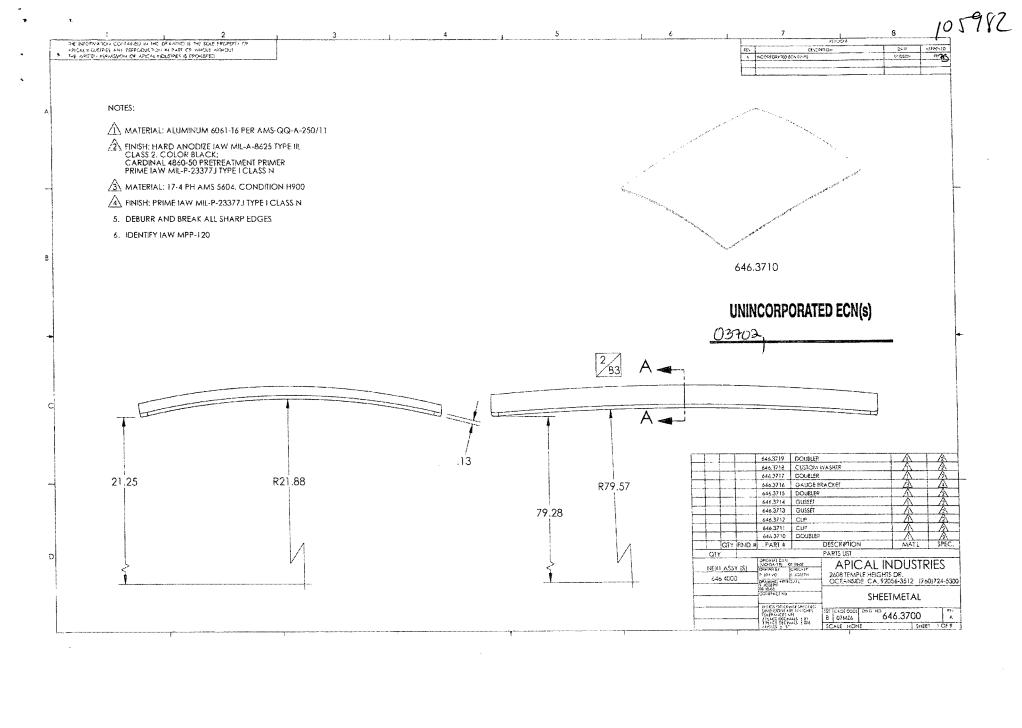
Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing Finish



										DQA:	Date:	:
NCR: Y	es / No				WORK ORDER NON-C	CON	NFORM	AANCE / UPI	DATE			,
										QA Closed:	Date	: <u> </u>
Work Orde	ır.				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part N					Scrap Machining Small Fab Use-as-is Thermoforming Finishing				Crosstube Small Fab Finishing	4	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR N	lo				Work Order Update			Large Fab	Composite]	Supplier	
Root				Descri	ption of work order update	lı	nitial	Act	tion	Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Desci	ription	Date	Verification	QC Inspector
Doc/Data												
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Other												
Process												
Supplier			ļ							:		
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Landi	ng Gear				General				_	- -	_	_
	Bending				Bend		Grain			Ovalized		Pressure/Forced
	Centre N	ot Conce	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
	Cracks			<u> </u>	Broken/Damaged	Ш	Inspecti	on Incomplete		Part Incorre	ct _	Weld
	Crushed/	'Crimped			Burrs		Instruct	ions Incomplete/	Unclear	Part Lost/M	issing	Wrong Stock Pulled
,	Cuffs				Contamination		Mainte	nance		Part Moved		
	Heat Tre	at			Countersink		Mislabe	led		Positioned \	Vrong	_
	Inspection	n Strip in	Tube		Cut Too Short		Misread	1		Power Loss/	Surge	Other
	Ripples ii	n Bend			Drill Holes		Offset					

Out of Sequence

Outside Dimensions

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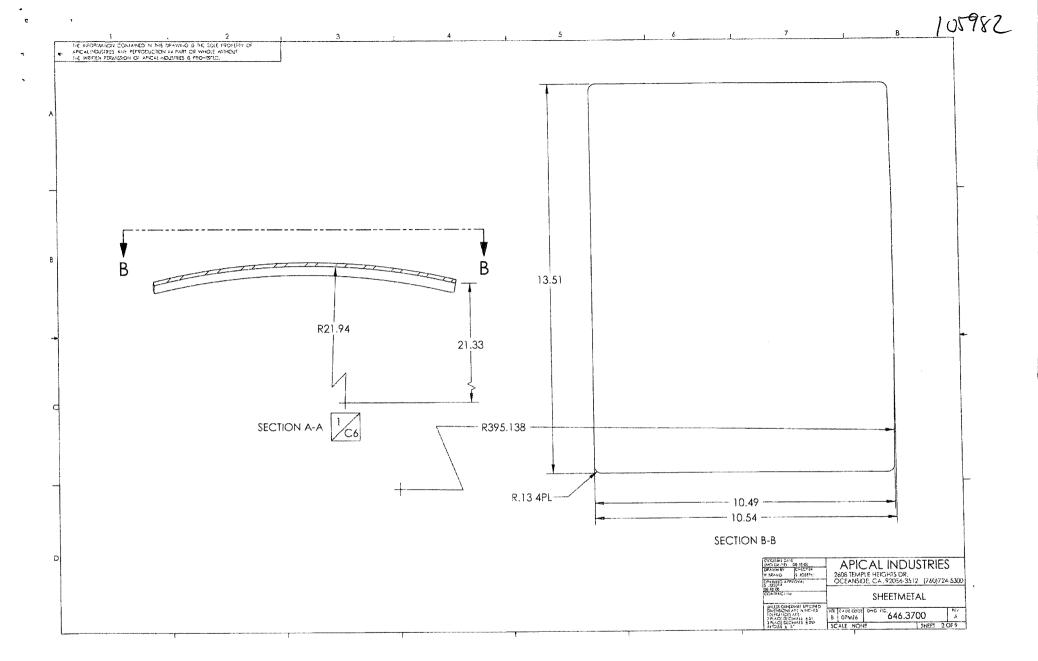
Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish



											DQA:	Dat	te:	
NCR:	⁄es	/ No				WORK ORDER NON-	100	NFORM	AANCE / UPDA			_	•	
											QA Closed:	Dat	te:	
Work Orde	or.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS		
WOLK OTAL	-1.					Rework	1		Skid-tube	Crosstube		Water Jet		Engineering
Part N	No.					Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.		Quality
	,					Use-as-is	1		noforming	Finishing		re/Packaging		Other
NCR I	No.					Work Order Update	1		~ 	Composite		Supplier		
	•					<u></u>	1					•		
Root					Descri	ption of work order update	1	Initial	Actio	on	Sign &			
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Descrip	otion	Date	Verification	1	QC Inspector
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	\vdash	Cracks	or conce	יונוונינטי	^{0/3}	Broken/Damaged	-	4	on Incomplete		Part Incorre	4		Weld
	\vdash	Crushed/	Crimned		-	Burrs	\vdash	- 1 '	ions Incomplete/Un	oclear	Part Lost/M		_	Wrong Stock Pulled
	<u> </u>	Cuffs	Cimpeu			Contamination	\vdash	Mainte	•	<u> </u>	Part Moved	····o	L	1110116 0100111 01100
		Heat Tre	at			Countersink		Mislabe		 	Positioned V	Vrong		
		Inspection		Tube		Cut Too Short		Misread			Power Loss/	- 1		Other
		Ripples in				Drill Holes		Offset		L		-		·

Out of Sequence

Outside Dimensions

Turning Sequence

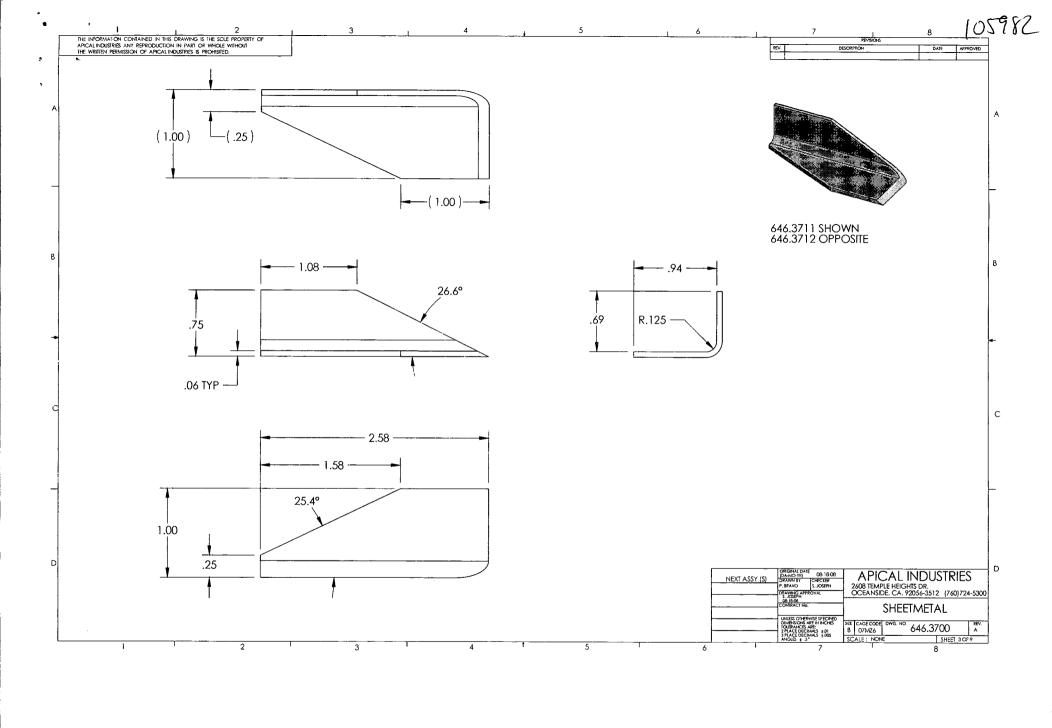
Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

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												DQA:	Da	te:	
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Work Orde	or.					DISPOSITION				AGAINST D	ÞΕ	PARTMENT	/PROCESS		
WOIK OIG	٠					Rework	ור		Skid-tube	Crosstube			Water Jet	Г	Engineering
Part I	۷o.					Scrap	1		Machining	Small Fab		Pro	d. Eng. Coor.		Quality
	٠٠.					Use-as-is	1		noforming	Finishing		1	re/Packaging	⊢	Other
NCR I	Vo.					Work Order Update	1		Large Fab	Composite		·	Supplier		
			•												
Root						ption of work order update	1	Initial		ction		Sign &			
Cause		Date	Step	Qty		or Non-conformance	Cr	ief Eng	Desc	ription		Date	Verificatio	<u>n</u>	QC Inspector
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Equip/Tooling	Щ														
Operator															
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Setup															
Other							1								
Process															
Supplier															
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							AUI	LT CATE	GORY						
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	<u></u>	Bending			-	Bend		Grain		-		Ovalized		\vdash	Pressure/Forced
	<u> </u>	Centre N	ot Concei	ntric to	o/s	BOM/Route	<u> </u>	Hardwa				Over/Under		\vdash	Temperature/Cure
	<u></u>	Cracks				Broken/Damaged		-1 '	ion Incomplete			Part Incorre		\vdash	Weld
		Crushed/	Crimped		ot	Burrs		-1	ions Incomplete,	/Unclear		Part Lost/Mi	issing		Wrong Stock Pulled
		Cuffs				Contamination	\perp	Mainte		Ļ		Part Moved			
		Heat Trea	at			Countersink		Mislabe	eled	Ļ		Positioned V	_		-
		Inspectio	n Strip in	Tube		Cut Too Short		Misread	t			Power Loss/	Surge		Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

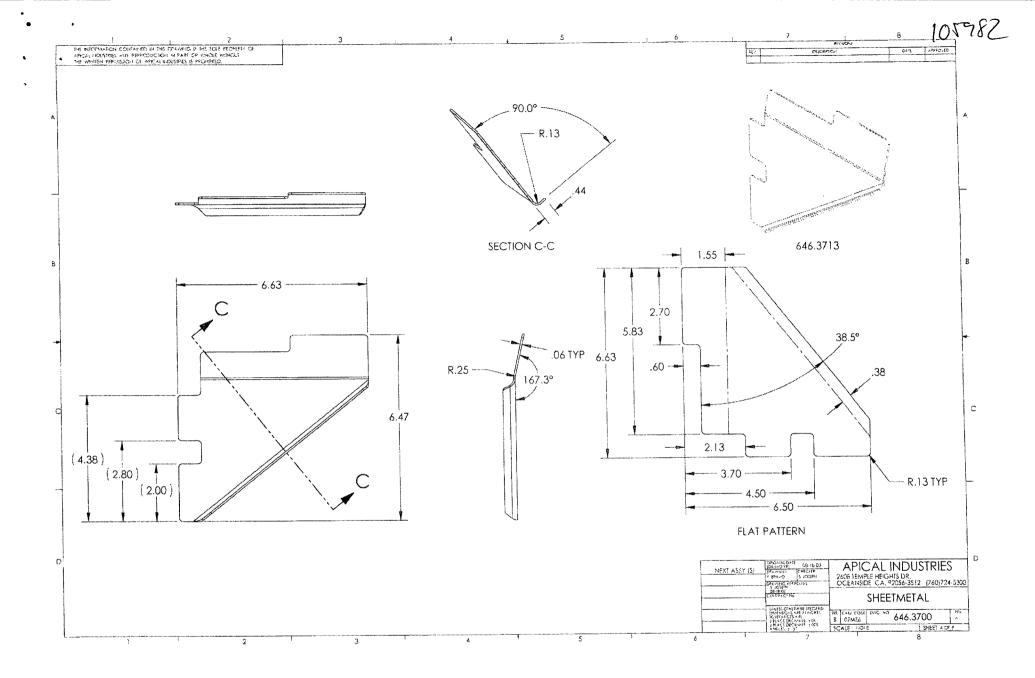
Torque Waves in Extrusion

Drill Holes

Drawing

Finish

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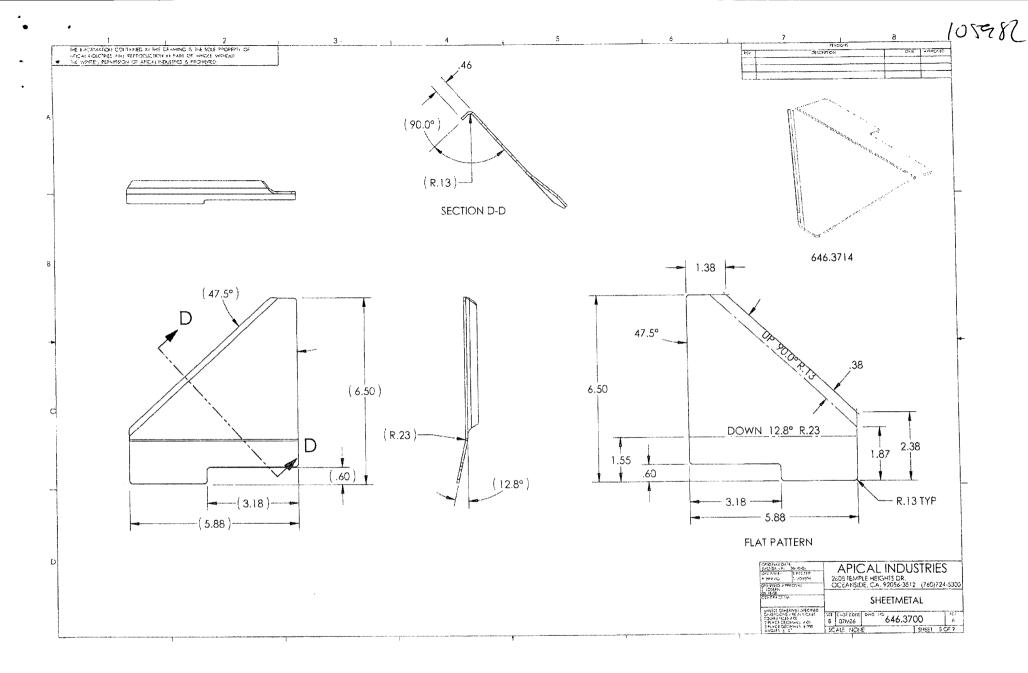
	DQA:	Date:
1110011 00000 11011 0011 0011 1100 1 1100 1 TE		

NCR: Yes / No

WORK ORDER NON-CONFORMANCE /	UPDATE
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							-		QA Closed:	Date	•
Work Orde					DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part N	lo.				Rework Scrap Use-as-is Work Order Update	The	Skid-tube Machining ermoforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descri	ption of work order update	Initia	I A	ction	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief E	ng Des	cription	Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling											
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	Bending			_	Bend	Grai		-	Ovalized	<u> </u>	Pressure/Forced
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	Cracks	(C: 1		 	Broken/Damaged		ection Incomplete	(1)	Part Incorred	⊢	Weld
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	Heat Tre		Tubo	-	Countersink Cut Too Short	Misr		<u> </u>	Positioned v		Other
	Ripples in	•	iuse	-	Drill Holes	Offs		L.	Trower ross/	Juige	Tottlet
	⊢ ``	ri Berio Vaves in l	Evtrucion	<u>,</u>	Drawing	—	er of Calibration				
	⊢ ⊣ `	Sequence		'' <u> </u>	Finish	\vdash	of Sequence				
	Wave/Tv	•		.	Folio		side Dimensions				

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											DQ	A : D	ate:	
NCR: Y	⁄es	/ No				WORK ORDER NON-	COI	NFORN	IANCE / UP	DATE			,	Ą
											QA Close	d: D	ate:	•
Work Orde	or.					DISPOSITION				AGAINST DE	PARTMEN	T/PROCESS		
	-					Rework	7		Skid-tube	Crosstube	7	Water Je	t∏	Engineering
Part N	No.					Scrap	1		Machining	Small Fab	Pı	rod. Eng. Coor	-	Quality
	-					Use-as-is]	Therm	oforming	Finishing	Rec/St	ore/Packagin		Other
NCR N	۷o. ₋			·····		Work Order Update]		Large Fab	Composite]	Supplie	r	
Root	I				Descri	ption of work order update		nitial	Ac	tion	Sign &			
Cause		Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verificati	on	QC Inspector
Doc/Data	Ш													
Equip/Tooling	Ш													
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	-	Bending			_	Bend	<u></u>	Grain			Ovalized			Pressure/Forced
	-	Centre N	ot Conce	ntric to	o/s	BOM/Route	\vdash	Hardwa			⊣ '	er tolerance	<u> </u>	Temperature/Cure
	\vdash	Cracks			<u> </u>	Broken/Damaged		1 '	on Incomplete		Part Incor		<u> </u>	Weld
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	Ш	Heat Tre	at		L	Countersink	L	Mislabe	led	<u>_</u>	Positioned	l Wrong		•
		Inspection	n Strip in	Tube		Cut Too Short		Misread			Power Los	s/Surge		Other
1	1	Rinnlas i	n Rond			Drill Holes	1	Offcot						

Outside Dimensions

Out of Sequence

Turning Sequence

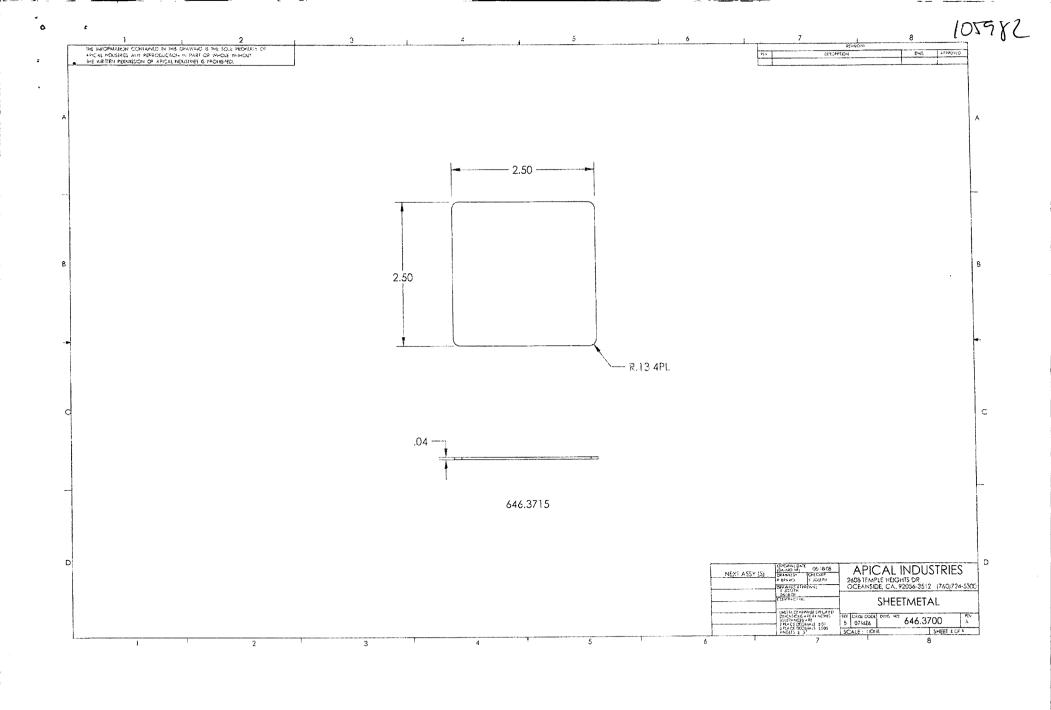
Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

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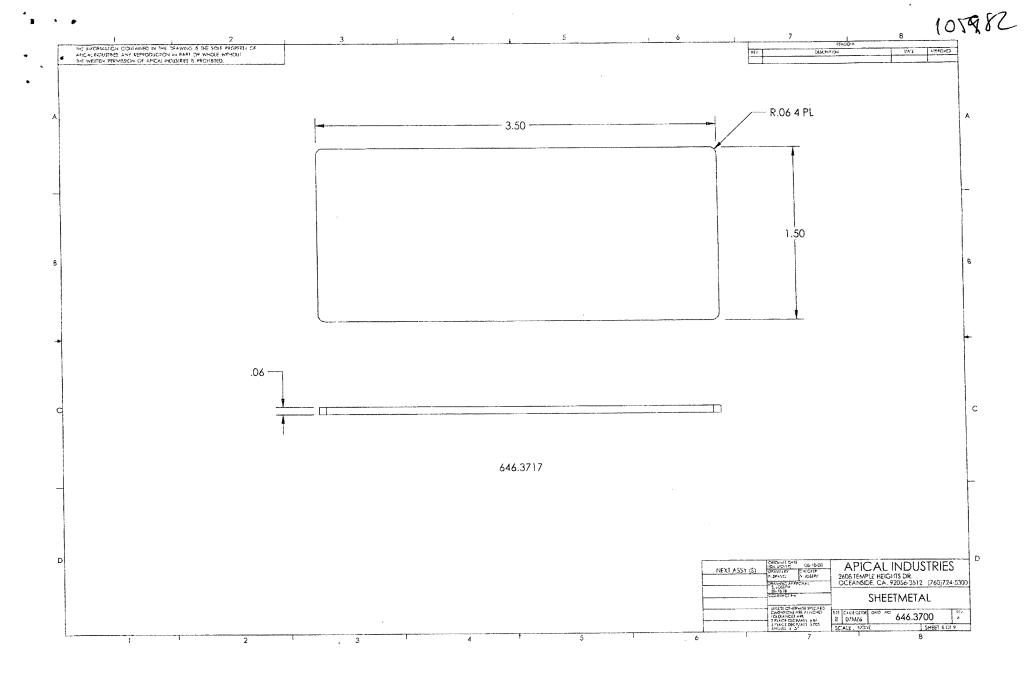
DQA:	Date:	
		

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

											QA Closed:	Dat	e:			
Work Orde	er:					DISPOSITION			AGAINST DEPARTMENT/PROCESS							
Part N	- oo					Rework Scrap Use-as-is Work Order Update	f Therm	Skid-tube Crosstube Water Jet Engine Machining Small Fab Prod. Eng. Coor. Composite Supplier								
Root					Descri	ption of work order update	Ī	nitial	Ac	tion	Sign &					
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	cription	Date	Verification	QC Inspector			
Doc/Data						,			,							
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Landi	ng G	ear				General		_		_	_					
		Bending			L	Bend		Grain			Ovalized		Pressure/Forced			
	Ш	Centre No	ot Concer	ntric to	o/s	BOM/Route		Hardwa	ire		Over/Under	tolerance	Temperature/Cure			
	Ш	Cracks				Broken/Damaged		Inspecti	ion Incomplete		Part Incorred	t [Weld			
		Crushed/0	Crimped			Burrs		Instruct	ions Incomplete/	/Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled			
	Ш	Cuffs				Contamination		Mainte	enance		Part Moved					
	\bigsqcup	Heat Trea	t			Countersink		Mislabe	eled		Positioned V	Vrong				
		Inspection	n Strip in	Tube		Cut Too Short		Misread	t		Power Loss/	Surge	Other			
	Ш	Ripples in	Bend			Drill Holes		Offset								
	Ш	Torque W	aves in E	xtrusio	n	Drawing		Out of (Calibration							
	Ш	Turning S	equence			Finish		Out of 9	Sequence							
		Wave/Tw	ist in Tub	эе		Folio		Outside	Dimensions							

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											DQA	Date:	
NCR: Y	⁄es	/ No				WORK ORDER NON-	COI	NFORN	MANCE / UP	DATE	QA Closed	. Date:	
	-					DISPOSITION				AGAINST DE		1.111 	
Work Orde	er: .					_	٦ :	1			7	_	.
Part N	No.					Rework Scrap Use-as-is			Skid-tube Crosstube Machining Small Fab Thermoforming Finishing			Water Jet od. Eng. Coor. re/Packaging	Engineering Quality Other
NCR I	No.					Work Order Update			Large Fab	Composite]	Supplier	
Root					Descri	otion of work order update		Initial	Ac	tion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ct	nief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling											-		
Operator		:											·
Material													
Setup													
Other													
Process													
Supplier			1										
Training													
Unapproved	Г			1									
							FAUI	LT CATE	GORY				
Landi	ng (Gear				General		_					_
		Bending				Bend		Grain			Ovalized		Pressure/Forced
		Centre N	ot Conce	ntric to	o/s	BOM/Route		Hardwa	re		Over/Unde	r tolerance	Temperature/Cure
ļ		Cracks				Broken/Damaged	Г	Inspecti	on Incomplete		Part Incorre	ect	Weld
		Crushed/	Crimped			Burrs		Instruct	ions Incomplete/	Unclear	Part Lost/N	lissing	Wrong Stock Pulled
		Cuffs				Contamination		Mainte	nance		Part Moved		_
	Г	Heat Tre	at			Countersink		Mislabe	led		Positioned	Wrong	
		Inspection	n Strip in	Tube		Cut Too Short		Misread	I		Power Loss	/Surge	Other
		Ripples i	n Bend			Drill Holes		Offset		<u> </u>			

Out of Sequence

Outside Dimensions

Turning Sequence

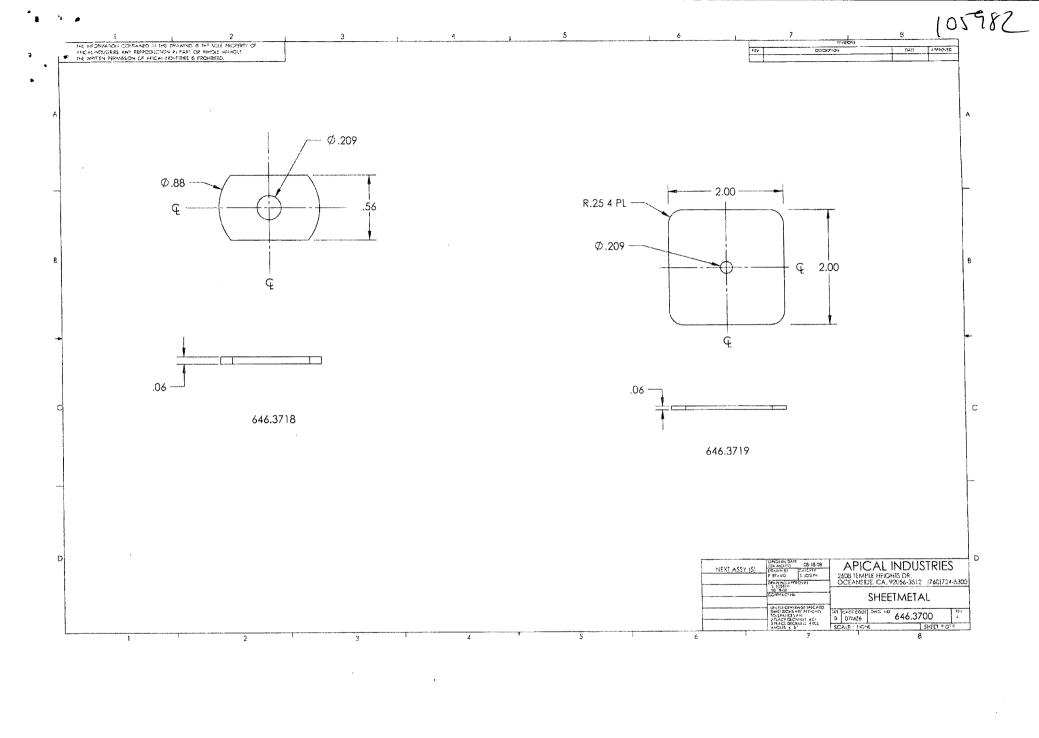
Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish Folio

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DQA: Date: **WORK ORDER NON-CONFORMANCE / UPDATE** NCR: Yes / No QA Closed: Date: **AGAINST DEPARTMENT/PROCESS** DISPOSITION Work Order: Skid-tube Crosstube Engineering Water Jet Rework Part No. Machining Small Fab Prod. Eng. Coor. Quality Scrap Thermoforming Rec/Store/Packaging Other Use-as-is Finishing NCR No. Work Order Update Large Fab Composite Supplier Description of work order update Initial Action Sign & Root Chief Eng Date Step Qty or Non-conformance Description Date Verification QC Inspector Cause Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved **FAULT CATEGORY Landing Gear** General Bend Grain Ovalized Pressure/Forced Bending Centre Not Concentric to O/S BOM/Route Over/Under tolerance Hardware Temperature/Cure Broken/Damaged Inspection Incomplete Cracks Part Incorrect Weld

Instructions Incomplete/Unclear

Maintenance

Out of Calibration

Outside Dimensions

Out of Sequence

Mislabeled

Misread

Offset

Wrong Stock Pulled

Other

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

Part Moved

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Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Crushed/Crimped

Inspection Strip in Tube

Torque Waves in Extrusion

Cuffs

Heat Treat

Burrs

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

DART AEROSPACE LTD	Work Order:	105907
Description: Double-	Part Number:	(646.3717
Inspection Dwg: 446・3元以 Reviへ		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.50"	the 030' 1	1.509"	1		U	Jimoi
0.063°	٠١	3 506° 0.061°	_		V	
0.063	110.00°	0.061"	_		v	
			<u> </u>			
		,				
	<u> </u>					
			DAS 27			

Measured by:	Jm	Audited by:	9-89	Preliminary Approval:	
Date:	13-10-06	Date:	13108	Date:	•

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

A 10.04.15



A.T.G. Industries Inc. 731, rue Industrielle Rd. PLATING DEPARTMENT Rockland, On K4K 1T2 Canada

Ph: (613) 446-4544 Fax: (613) 446-4556

Pack List

Number: 62714

Date: 31-Oct-13

То

DART AEROSPACE LTD 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 Canada Ship To

DART AEROSPACE LTD 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7

Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

Terms		Ship Via				
Quantity	Description					
1	Part: ASST		Rev:	i		
lot						
	10 PCS D4726-1 (2.55) HARD ANODIZE BLACK					
	MIL-A-8625 TYPE III CLASS 2					
	8 PCS 646.3011 (10.25)					
	2 PCS 646.3110 (10.65)					
·	8 PCS 646.3313 (13.10) 24 PCS 646.3717 (6.25)					
	26 PCS 646.3719 (6.25)	,				
	40 PCS 647.9611 (16.30) 8 PCS 646.3311 (18.10)					
	10 FUS 040.3311 (16.10)	•				
	HARD ANODIZE BLACK					
	MIL-A-8625 TYPE III CLASS 2					
	PRIME MIL-P-23377J TYPE I CLA	N SS N				
	PRICE IS PER PIECE					
	Job: 20130678	PO: 21634	Line:			
	Certificate of Co	onformance				
	A.T.G. Industries certifies that all items with all requirements, specifications ar	s in this shipment are in cond drawings referenced in	onformance the purchase order.			
	ISO 9001 : 2008 REGISTERED ATG SALES-2010 TERMS APPLY					
	DATE 31/10/13					
	CERTIFIED SIGNATURE :					
	RECEIVER SIGNATURE :					